

DUPONT™ EXCEL™ ACRYLIC URETHANE TOPCOAT

TYPE

A high performance, low VOC (<3.5 & 2.8 lbs/gal), two-component acrylic urethane enamel, ready-to-spray topcoat.

DESCRIPTION

DuPont™ Excel™ is a single-stage acrylic urethane that provides good durability and color capability at a maximum applied voc of 3.5 & 2.8 lbs/gal. Stock numbers for DuPont™ Excel™ 3.5 VOC mixing colors codes end with "TN" and DuPont™ Excel™ 2.8 VOC will end with "TK".

SUGGESTED USES

A high-gloss, durable, chemical and solvent resistant air-dry enamel that is available in both solid and metallic colors in "TN" quality. It is an extremely versatile product and is recommended for overall repainting of older delivery vehicles, trucks, trailers, busses, heavy equipment; fleet rebranding; refurbishing of trailers and transportation equipment; and other applications where an economical finish is required.

NOT RECOMMENDED FOR

- Immersion service
- Use over lacquer finishes.

COMPATIBILITY WITH OTHER COATINGS

- Compatible with all DuPont OEM/Commercial Finishes primer systems

DRY FILM CHARACTERISTICS

Chemical Resistance	EXCELLENT
Weatherability	VERY GOOD
Humidity Resistance	EXCELLENT
Acid Resistance	EXCELLENT
Solvent Resistance	VERY GOOD
Abrasion Resistance	EXCELLENT
Flexibility	EXCELLENT

MAXIMUM SERVICE TEMPERATURE

- 200°F (92°C) in continuous or intermittent service

VOLUME SOLIDS – WILL VARY WITH COLOR SELECTED

"TN"

- 50.5 % average unactivated
- 51.5% average RTS mixed 3:1 w/895S™ Activator

"TK"

- 55.0 % average unactivated
- 64.5 % average RTS mixed 3:1 w/885S™ Activator

WEIGHT SOLIDS – WILL VARY WITH COLOR SELECTED

"TN"

- 60.6% average unactivated
- 61.5% average RTS mixed 3:1 with DuPont™ 895S™ Activator

"TK"

- 64.9% average unactivated
- 72.4% average RTS mixed 3:1 with DuPont™ 885S™ Activator

WEIGHT PER GALLON

- "TN" - 9.36 lbs/gal average unactivated
- "TK" - 9.45 lbs/gal average unactivated

SUGGESTED DRY FILM THICKNESS

- 1.8 – 2.2 mils

THEORETICAL COVERAGE PER GALLON

- "TN" - 824 sq. ft./gal average @ 1 mil DFT
- "TK" - 1034 sq. ft./gal average @ 1 mil DFT

GLOSS

- High
- DuPont™ Imron® 8928S™ Flattening Base is available to obtain lower gloss if desired. The amount added varies (depending on the color).

COLOR

- Available in solid or metallic colors in "TN" quality

FLASH POINT (CLOSED CUP)

- Below 80°F

SHELF LIFE

- 12 months minimum

APPLICATION SOLVENTS

- Ready to spray below 3.5 or 2.8 lbs/gal VOC upon activation. Further reduction will result in greater than 3.5 or 2.8 lbs/gal VOC.

CLEANUP SOLVENTS

- DuPont™ 3602S™ Thinner
- DuPont™ 8685S™ Reducer

A DuPont OEM / Commercial Finishes Product



DUPONT™ EXCEL™ ACRYLIC URETHANE TOPCOAT

ACTIVATION (MIX RATIO)

Add 3 parts DuPont™ Excel™ with 1 part DuPont™ 895S™ or DuPont™ 885S™ and mix thoroughly. Filter material prior to spray application. To the activated gallon, add up to 2 oz. DuPont™ MasterTint® 389S™ or 1 oz. DuPont™ MasterTint® 8989S™ Accelerator. (Note: DuPont™ MasterTint® 8989S™ will shorten pot life.) Product upon activation will have a viscosity of 9-20 seconds in a Zahn #3 cup, depending on color.

INDUCTION TIME

- No induction time required

POT LIFE

- 1 – 2 hrs at 70°F (21°C)
- 2 hours at 70°F (21°C) with DuPont™ MasterTint® 389S™
- 45 minutes at 70°F (21°C) with DuPont™ MasterTint® 8989S™

ADDITIONAL COMMENTS

- Heating activated material above 110°F (43°C) will cause gelation.
- When recoating DuPont™ Excel™ with itself, sanding is required if the enamel has air dried more than 16 hours or has been force dried.

APPLICATION CONDITIONS

Do not apply if material, substrate or ambient temperature is less than 50°F (10°C) or above 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%.

APPLICATION

- Thoroughly mix DuPont™ Excel™ prior to activation. The use of a cyclone paint shaker is recommended.
- For pressure pot, fluid delivery should be set for 10 – 12 oz/min.
- Use a cross-coat technique. With a gun distance of 8-10 inches, spray a medium-wet first pass using a side-to-side motion. Spray a medium-wet second pass using a top-to-bottom motion. Minimize flash time between passes for optimum appearance.
- Use 60-65 lbs air pressure at the gun for siphon equipment and 60-70 lbs air pressure for pressure pot application.
- Do not spray DuPont™ Excel™ if the paint temperature is less than 75°F (24°C). Use warm water or paint heaters to heat the paint to an optimum temperature of 85-95°F (29-35°C). (In case of fish eyes, add 1 oz DuPont™ 359S™ Paint Additive per ready to spray gallon of DuPont™ Excel™. Do not use FEE.)
- To the activated gallon, add up to 2 oz. DuPont™ MasterTint® 389S™ or 1 oz. DuPont™ MasterTint® 8989S™. DuPont™ Excel™ may also be force dried 30 minutes at 140°F (60°C).

CURE TIME AT RECOMMENDED THICKNESS – 77°F (25°C) & 50% RH – FOR EXCEL “TN”

	Without Accelerator	w/MasterTint® 389S™	w/MasterTint® 8989S™
▪ Dust Free	30 min	n/a	n/a
▪ Tack Free	n/a	1 hour	½ - 1 hour
▪ Tape Free	n/a	2 hours	1 hours
▪ Dry to Assemble	72 hours	72 hours	72 hours

Product may be force dried 30 min at 140°F (60°C) after a flash time of 15 min following application of final coat.

APPLICATION EQUIPMENT

- Pressure Pot (recommended)
- Air Assisted Airless
- Airless
- Gravity Feed
- HVLP

ENVIRONMENTAL

VOC content (lbs/gal)	LE	AP
▪ Excel™ “TN” RTS mixed 3:1 w/895S	3.5	3.5
▪ Excel™ “TK” RTS mixed 3:1 w/885S	2.8	2.8

FOR VOC REGULATED AREAS

These directions refer to the use of products that may be restricted or require special mixing instructions in your area. Follow recommendations in the DuPont Compliant Products Chart for your area.

SAFETY AND HANDLING

DuPont is committed to helping you develop and maintain a safe working environment. Carefully read the specific warnings and precautions printed on the labels of all DuPont products before handling and using. These products are for industrial use by trained professional painters only.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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